

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/Ala Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014670**Date Inspected:** 19-Apr-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower and OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA Inspector) George Goulet was present during the times noted above for observations relative to the work being performed.

**Bay 11**

This QA Inspector randomly observed the following work in progress in Bay 11.

SMAW tack welding of weld joint ED1-STSA4-6-139M-2 located on PCMK east tower, lift 4, strut. Welder was identified as 053697. QC was identified as ZPMC CWI An Qing Xiang (QC1). The welding variables recorded by QC1 appeared to comply with WPS-B-T-4113.

ZPMC personnel lifted PCMK east tower, lift 4, using flat lifting straps at the temporary fenders. The tower section had been sitting on skin A. It was rotated it in the air using the flat straps and set it back down on skin C.

**Bay 10**

This QA Inspector randomly observed no apparent welding related work in progress in Bay 10.

**Heavy Dock**

This QA Inspector randomly observed no apparent welding related work in progress on the Heavy Dock. ABF Representative Zhao Ying Sheng informed this QA Inspector that ZPMC workers were performing fit-up of the vertical base plate between west tower lift 1 and south tower lift 1 and no welding was being performed.

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## WELDING INSPECTION REPORT

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OBG Trial Assembly Area

This QA Inspector randomly observed the following work in progress in the OBG Trial Assembly Area:

FCAW welding of weld joint SP368-001-025, 026, 027, 028 located inside PCMK OBG 7EE, T-stiffener to side plate holdback welds. Welder was identified as 070140. ZPMC QC was identified as ZPMC CWI Gu Rongjian(QC2). The welding variables recorded by QC2 appeared to comply with WPS-B-T-2132.

FCAW welding of weld joint SP368-001-033, 034, 035, 036 located inside PCMK OBG 7EE, T-stiffener to side plate holdback welds. Welder was identified as 222396. ZPMC QC was identified as QC2. The welding variables recorded by QC2 appeared to comply with WPS-B-T-2132.

FCAW welding of weld joint SP314-001-029, 030, 031, 032, 033, 034 located inside PCMK OBG 7EE, T-stiffener to side plate holdback welds. Welder was identified as 220069. ZPMC QC was identified as QC2. The welding variables recorded by QC2 appeared to comply with WPS-B-T-2132.

FCAW welding of weld joint SP465-001-021, 022, 023, 024 located inside PCMK OBG 7EE, T-stiffener to side plate holdback welds. Welder was identified as 220063. ZPMC QC was identified as QC2. The welding variables recorded by QC2 appeared to comply with WPS-B-T-2132.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

As noted above.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 150-0042-2372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Goulet,George	Quality Assurance Inspector
<b>Reviewed By:</b>	Dawson,Paul	QA Reviewer

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